

Date: Friday, 8/10/2007 10:28:32 AM  
 User: Jean-Luc Menard

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	WEARSHOE
Job Number	33867		
Estimate Number	12788		
P.O. Number	N/A	Part Number	D356413
This Issue	8/10/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D3564 REV C
First Issue	N/A	Project Number	N/A
Previous Run	33800	Drawing Revision	C
Written By	<u>JLM 07-08-10</u>	Material	N/A
Checked & Approved By		Due Date	8/17/2007
Comment	Est Rev:A New Issue 07-03-08 ec Est Rev:B As per Rev C 07-07-09 JLM		

## Additional Product

Job Number:			
Seq. #:	Machine Or Operation:	Description:	
1.0	M304S16GA	304/316 .063 Sheet	
			
Comment: Qty.: 0.1785 sf(s)/Unit Total : 8.9250 sf(s) M304S16GA Stainless steel sheet 0.063" thick Batch: M105130 <span style="float: right;">SAD 07/08/11</span>			
2.0	WATER JET	FLOW WATER JET	
			
Comment: FLOW WATER JET 1-Cut as per Dwg D3564 Dwg Rev: C Prog Rev: C			
2-Deburr if necessary		SAD 07/08/11 SAD 07/08/11 55	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <span style="float: right;">SAD 07/08/11 55</span>			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK <span style="float: right;">coated 155</span>			
5.0	BRAKE NC	NC BRAKE	
			
Comment: NC BRAKE Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT 3157 and DT 8179 <span style="float: right;">SAD 07/08/11 55</span>			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 33867

Part Number: D356413

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



counter

Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

En 07/09/19 (455)

7.0 POWDER COATING

POWDER COATING



65X

M104846

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M- 07/09/20

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

F2 07/09/20

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: F-16

U

07 - 09 - 20

55

10.0 QC21

FINAL INSPECTION/W/O RELEASE



55

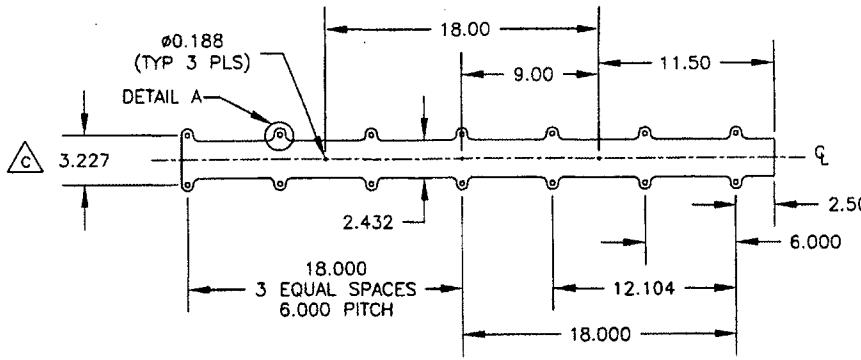
Comment: FINAL INSPECTION/W/O RELEASE

07/09/20

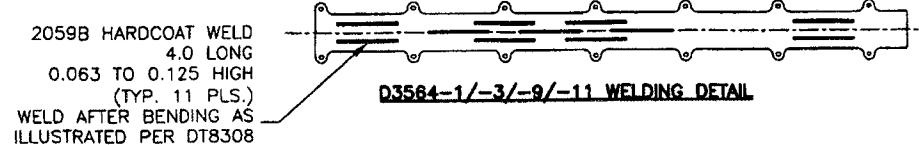
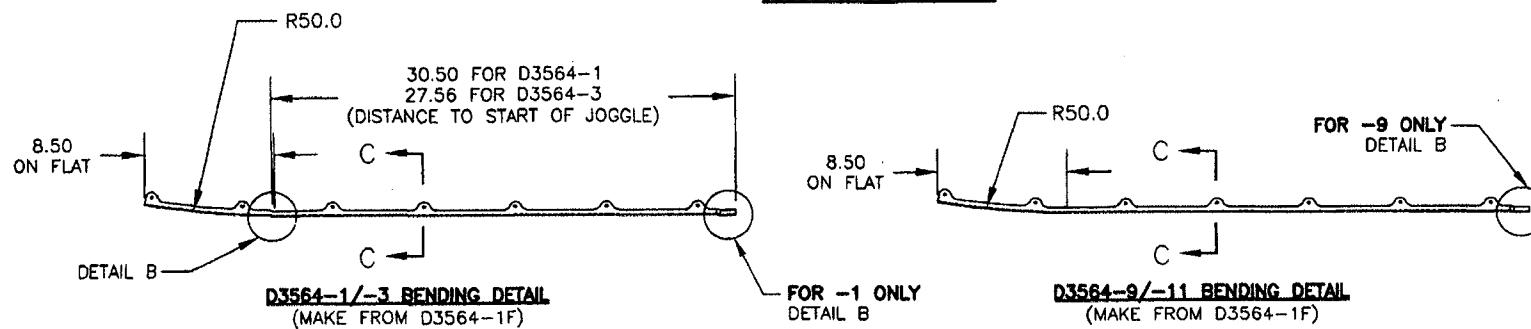
Job Completion



U 07-09-21



**D3564-1F FLAT PATTERN**



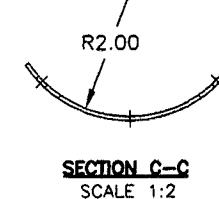
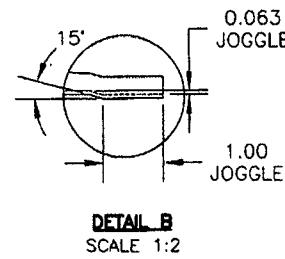
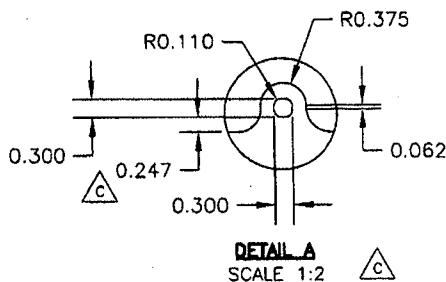
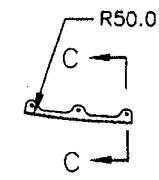
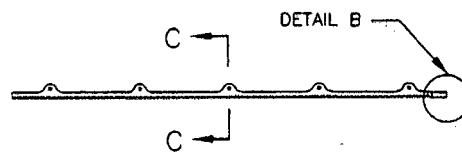
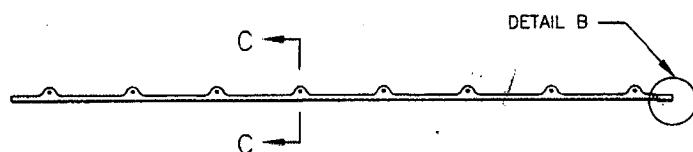
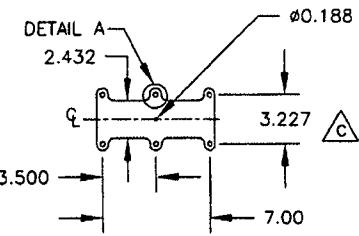
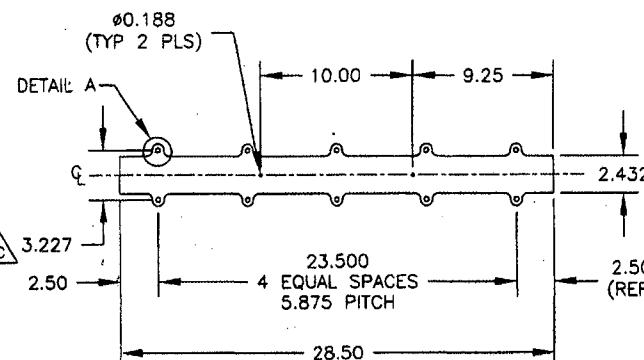
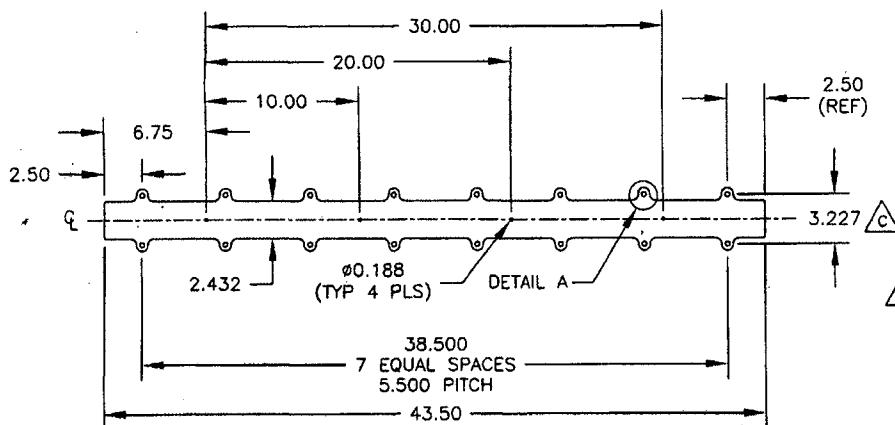
**D3564-1/-3/-5/-7/-9/-11/-13 WEARPLATE NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) PART IS SYMMETRICAL ABOUT CENTERLINE

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C	07.04.17	MOVE TAB OUTBOARD, DETAIL A
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.12.18	NEW ISSUE
DESIGN	DRAWN BY	DART
P4	P4	DART AEROSPACE LTD. HAWKSBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. REV. C D3564 SHEET 1 OF 2
DATE	TITLE	SCALE 07.04.17 WEARSHOE 1:8

RELEASED  
07.06.28



RELEASED  
07.06.28/11

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DATE 07.04.17	TITLE WEARSHOE	SCALE 1:8		

DART AEROSPACE LTD	Work Order:	33867
Description: Wearshoe	Part Number:	D3564-13
Inspection Dwg: D3564      Rev: C		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	SMP	Audited by:	EP	Prototype Approval:	N/A
Date:	07/08/11	Date:	07/08/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM	
B	07.07.18	Dimensions updated per Dwg Rev. C	KJ/JLM	E